

Work Order ID 54688

December 16, 2009 10:49:11 AM

Page 1

Item ID: D3890-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Gasket

Start Date: 12/16/09 Start Qty: 2.00

Cust Item ID:

Required Date: 12/18/09 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3890

A

0.00

100



Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut as per Dwg D3890

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

12-16

2

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

12-16

Work Order ID 54688

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Page 2

Item ID: D3890-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Gasket

Start Date: 12/16/09 Start Qty: 2.00



Cust Item ID:

Required Date: 12/18/09 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

2) Serial 16

x2

130

Identify as per dwg & Stock Location: GA

0.00



Packaging

Memo

0.00

Packaging

8B 09/12/17

2 0

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10-01-06

11 09/12/18 (2)

Picklist Print

December 16, 2009 10:49:11 AM

Page 1

Work Order ID: 54688

Parent Item: D3890-3

Parent Item Name: Gasket

Comments:

Start Date: 12/16/09

Required Date: 12/18/09

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M4111NS.125		Purchased	No			100	sf	322.3414	0.0547			



4111 Black Neoprene/EPDM/SBR Blend Sheet 0.125"

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

112335

322.3414

322.3414



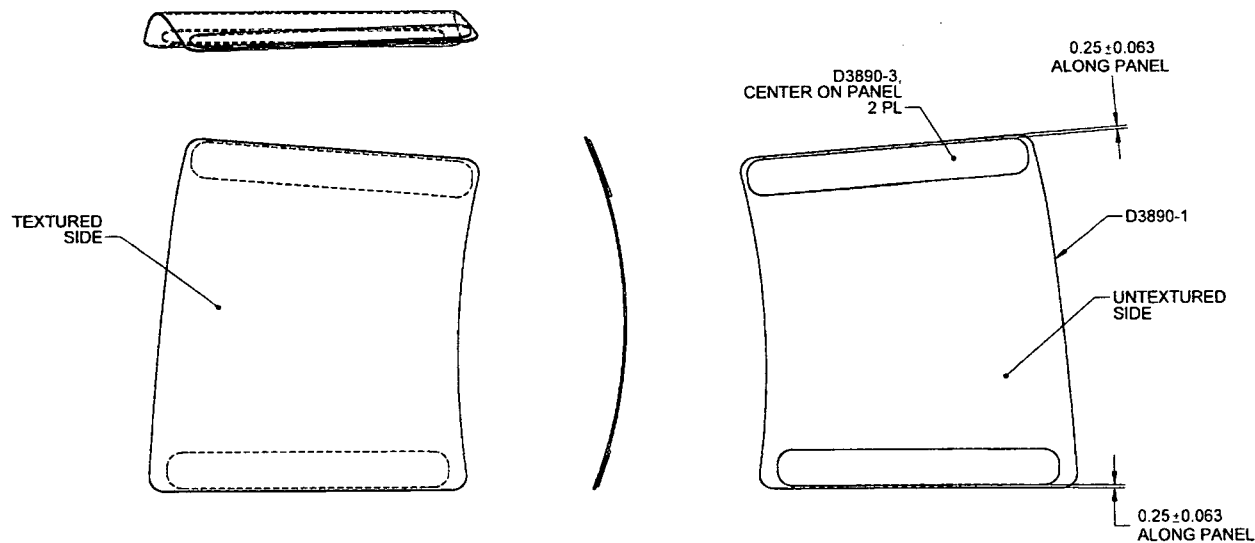
12-9-16

②

10338

PARTS LIST

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3890-041	PANEL, SIDE
2	1	D3890-1	PANEL
3	2	D3890-3	GASKET
5	A/R	3M 1300	ADHESIVE



D3890-041 PANEL, SIDE

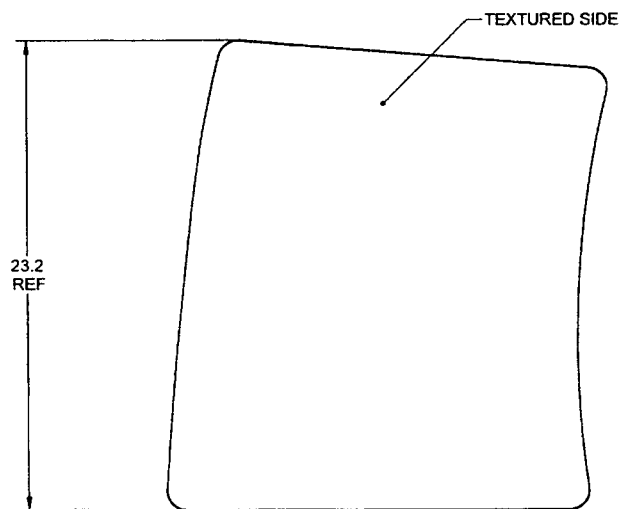
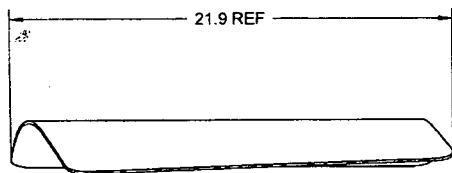
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3890-041" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH/UNTEXTURED SIDE OF PART
- 7) WEIGHT: 2.48 lbs
- 8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE.

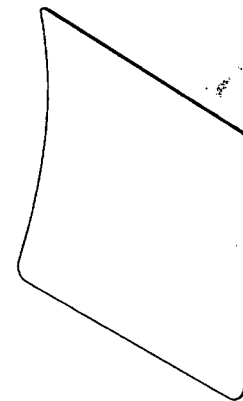
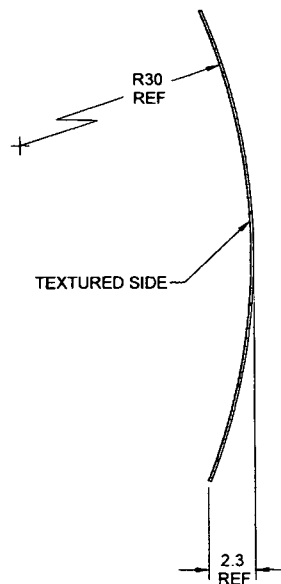
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 54688
PH 09-12-16

RELEASED
9/15/16 W/P

A	NEW ISSUE	CP	09.05.01
REV.	DESCRIPTION		BY DATE
DESIGN	92	DART AEROSPACE LTD	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	24	D3890	SHEET 1 OF 4
APPROVED	42	TITLE	SCALE
DE APPR.	42	PANEL, SIDE	NTS
DATE	09.05.01	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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D3890-1 PANEL

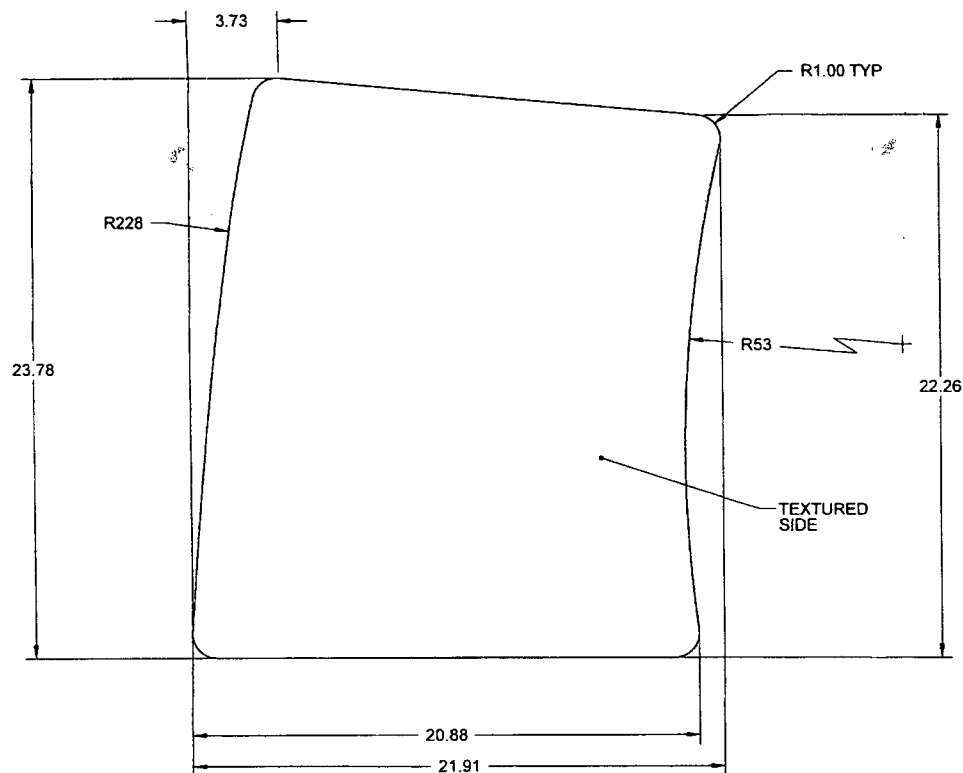


- NOTES:**
- 1) MATERIAL: MAKE FROM D3890-1F
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: NONE
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 2.45 lbs
 - 8) THERMOFORM USING MOLD DT9489 PER QSI 022

RELEASED
09/05/16

W/O 54688

DESIGN	92	DART AEROSPACE LTD	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	94	DRAWING NO.	REV. A
MFG. APPR.	94	D3890	SHEET 2 OF 4
APPROVED	140	TITLE	SCALE
DE APPR.	94	PANEL, SIDE	NTS
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D3890-1F PANEL

NOTES:

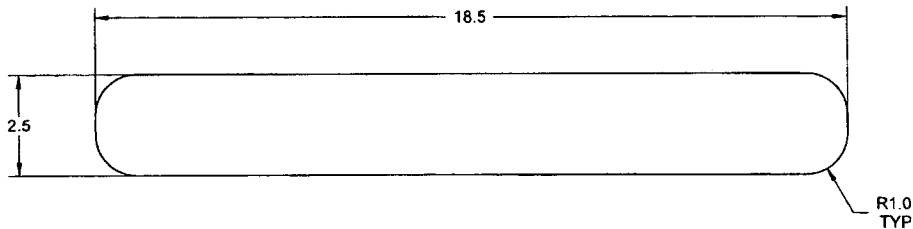
- 1) MATERIAL: F60029 GY3778 LEXAN SHEET (HEAVY HAIRCELL TEXTURE, DARK GREY), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC. MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.45 lbs

RELEASED
09/06/16

W/O 34688

DESIGN	92	DART AEROSPACE LTD	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	21	D3890	SHEET 3 OF 4
APPROVED	149	TITLE	SCALE
DE APPR.	14	PANEL, SIDE	NTS
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0.125
REF



D3890-3 GASKET

NOTES:

- 1) MATERIAL: NEOPRENE FOAM SHEET, 0.125 THICK
(REF DART SPEC. M4111N-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

RELEASED
21/06/14 MTD

W/0 34688

DESIGN	97	DART AEROSPACE LTD	
DRAWN	97	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	21	D3890	SHEET 4 OF 4
APPROVED	21	TITLE	SCALE
DE APPR.	21	PANEL, SIDE	NTS
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